

Work Order ID 98362

98362

Page 1

March-12-13 1:48:32 PM

Item ID: D2232-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop *NS2*

Start Date: 3/11/13

Start Qty: 20.00

20

Cust Item ID:

Required Date: 3/22/13

Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan: Mfg

Date: 13-03-14 Tooling:

Date:

Run Start

NR1

OC

Date: **SPG CX/ND**

Dataset

Stop

END

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

| Work Order: _____ | | | DISPOSITION | | AGAINST DEPARTMENT/PROCESS | | | | | | |
|---|------|------|---|---|--|---|---------------------------------|--------------|--------------|--|--|
| | | | Rework Scrap Use-as-is Work Order Update | Skid-tube Machining Thermoforming Large Fab | Crosstube Small Fab Finishing Composite | Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier | Engineering Quality Other | | | | |
| Part No. _____ NCR No. _____ | | | | | | | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | | |
| Doc/Data | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | |
| Operator | | | | | | | | | | | |
| Material | | | | | | | | | | | |
| Setup | | | | | | | | | | | |
| Other | | | | | | | | | | | |
| Process | | | | | | | | | | | |
| Supplier | | | | | | | | | | | |
| Training | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | |
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | | | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Other | |
| | | | | | | | | | | | |
| | | | | | | | | | | | |
| | | | | | | | | | | | |

Work Order ID 98362***98362***

Page 2

March-12-13 1:48:32 PM

Item ID: D2232-1

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Basket Hinge

Stop

NS2

Start Date: 3/11/13

Start Qty: 20.00

20

Cust Item ID:

Required Date: 3/22/13

Req'd Qty: 20.00

20

Customer:

Reference:

| | | | | | | | |
|------------|---------------|-------|------------|-------|-----|-------|--------------|
| Approvals: | Process Plan: | Date: | Tooling: | Date: | Run | Start | *NR1* |
| | QC: | Date: | SPC (Y/N): | Date: | | Stop | *NR2* |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|----------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 *130* Packaging | Identify as per dwg & Stock Location: Memo | 0.00 0.00 | | | | | | | |
| | *****STOCK IN BASKET CELL***** | | | | | | | | |

| | | | | | | | | | |
|---------------------------|---|--------------|--|--|--|--|--|--|--|
| 140 *140* QC | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | | |
|---------------------------|---|--------------|--|--|--|--|--|--|--|

Quality Control

20x 13-03-20

NLJ 13-03-22

ME
13-3-22

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

| Work Order: _____ | | | DISPOSITION | | AGAINST DEPARTMENT/PROCESS | | | | | |
|--|------|------|---|---|---------------------------------------|---|---|--------------|--------------|--|
| | | | Rework <input type="checkbox"/> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | |
| | | | Scrap <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coor. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | |
| | | | Use-as-is <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | |
| | | | Work Order Update <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | |
| Doc/Data <input type="checkbox"/> | | | | | | | | | | |
| Equip/Tooling <input type="checkbox"/> | | | | | | | | | | |
| Operator <input type="checkbox"/> | | | | | | | | | | |
| Material <input type="checkbox"/> | | | | | | | | | | |
| Setup <input type="checkbox"/> | | | | | | | | | | |
| Other <input type="checkbox"/> | | | | | | | | | | |
| Process <input type="checkbox"/> | | | | | | | | | | |
| Supplier <input type="checkbox"/> | | | | | | | | | | |
| Training <input type="checkbox"/> | | | | | | | | | | |
| Unapproved <input type="checkbox"/> | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | |
| Landing Gear | | | | General | | | | | | |
| <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | | <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | | | | | | |
| | | | | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | | | | | | |
| | | | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | | | | | | |
| | | | | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled | | | | | | |
| | | | | <input type="checkbox"/> Other | | | | | | |

Picklist Print

March-12-13 1:48:31 PM

Page 1

Work Order ID: 98362

Parent Item: D2232-1

Parent Item Name: Basket Hinge

Start Date: 3/11/13

Required Date: 3/22/13

Start Qty: 20.00

Required Qty: 20.00

Comments: IPPB01.06.07Now laser cutEC
IPP Rev:C Now on Waterjet 06-11-21 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|----------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|-----------------|---------------|----------------|--------|
| M304S11GA 304/316 0.125 Sheet | | Purchased | No | | | 100 | sf | 258.0000 | 0.0243 | 0.511578 0.6 | | Jm13-3-21 | |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| MAT020 | 258 | |
| 122521 | 66 | |
| 24445 | 192 | 122521 |

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| Work Order: _____ | | | DISPOSITION | | | AGAINST DEPARTMENT/PROCESS | | | | | | | | | | | | | | | | | | |
|-------------------|---|--|--|---|---|---|---|---|--|---------------------------------------|---------------------------------------|--|---|--|--|---|---|---|--|--|--|----------------------------------|--|-----------------------------------|
| | | | Rework <input type="checkbox"/> | Scrap <input type="checkbox"/> | Use-as-is <input type="checkbox"/> | Skid-tube <input type="checkbox"/> | Machining <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Finishing <input type="checkbox"/> | Composite <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Prod. Eng. Coor. <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Supplier <input type="checkbox"/> | Engineering <input type="checkbox"/> | Quality <input type="checkbox"/> | Other <input type="checkbox"/> | | | | |
| Part No. _____ | | | Work Order Update <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | |
| NCR No. _____ | | | | | | | | | | | | | | | | | | | | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | | | Initial Chief Eng | Action Description | | | Sign & Date | Verification | QC Inspector | | | | | | | | | | | |
| Doc/Data | | | | | | | | | | | | | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | | | | | | | | | | | | | |
| Operator | | | | | | | | | | | | | | | | | | | | | | | | |
| Material | | | | | | | | | | | | | | | | | | | | | | | | |
| Setup | | | | | | | | | | | | | | | | | | | | | | | | |
| Other | | | | | | | | | | | | | | | | | | | | | | | | |
| Process | | | | | | | | | | | | | | | | | | | | | | | | |
| Supplier | | | | | | | | | | | | | | | | | | | | | | | | |
| Training | | | | | | | | | | | | | | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | | | | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | | | | | | | | | | | | | | |
| Landing Gear | General | | | | Grain | | | | Ovalized | | | | Pressure/Forced | | | | | | | | | | | |
| | Bending <input type="checkbox"/> | Bend <input type="checkbox"/> | Centre Not Concentric to O/S <input type="checkbox"/> | BOM/Route <input type="checkbox"/> | Hardware <input type="checkbox"/> | Inspection Incomplete <input type="checkbox"/> | Instructions Incomplete/Unclear <input type="checkbox"/> | Maintenance <input type="checkbox"/> | Mislabeled <input type="checkbox"/> | Misread <input type="checkbox"/> | Offset <input type="checkbox"/> | Out of Calibration <input type="checkbox"/> | Out of Sequence <input type="checkbox"/> | Outside Dimensions <input type="checkbox"/> | Over/Under tolerance <input type="checkbox"/> | Part Incorrect <input type="checkbox"/> | Part Lost/Missing <input type="checkbox"/> | Part Moved <input type="checkbox"/> | Positioned Wrong <input type="checkbox"/> | Power Loss/Surge <input type="checkbox"/> | Temperature/Cure <input type="checkbox"/> | Weld <input type="checkbox"/> | Wrong Stock Pulled <input type="checkbox"/> | Other <input type="checkbox"/> |
| | Cracks <input type="checkbox"/> | Broken/Damaged <input type="checkbox"/> | Contamination <input type="checkbox"/> | Countersink <input type="checkbox"/> | Cut Too Short <input type="checkbox"/> | Drill Holes <input type="checkbox"/> | Drawing <input type="checkbox"/> | Finish <input type="checkbox"/> | Folio <input type="checkbox"/> | | | | | | | | | | | | | | | |
| | Crushed/Crimped <input type="checkbox"/> | Burrs <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | |
| | Cuffs <input type="checkbox"/> | Contamination <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | |
| | Heat Treat <input type="checkbox"/> | Countersink <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | |
| | Inspection Strip in Tube <input type="checkbox"/> | Cut Too Short <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | |
| | Ripples in Bend <input type="checkbox"/> | Drill Holes <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | |
| | Torque Waves in Extrusion <input type="checkbox"/> | Drawing <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | |
| | Turning Sequence <input type="checkbox"/> | Finish <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | |
| | Wave/Twist in Tube <input type="checkbox"/> | Folio <input type="checkbox"/> | | | | | | | | | | | | | | | | | | | | | | |

| | | |
|---------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 98362 |
| Description: Basket Hinge | Part Number: | D2232-1 |
| Inspection Dwg: D2232 | Rev: C | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

| | | | | | |
|--------------|---------|-------------|---------|---------------------|-----|
| Measured by: | Jm | Audited by: | SMB | Prototype Approval: | N/A |
| Date: | 13-3-21 | Date: | 13-3-21 | Date: | N/A |

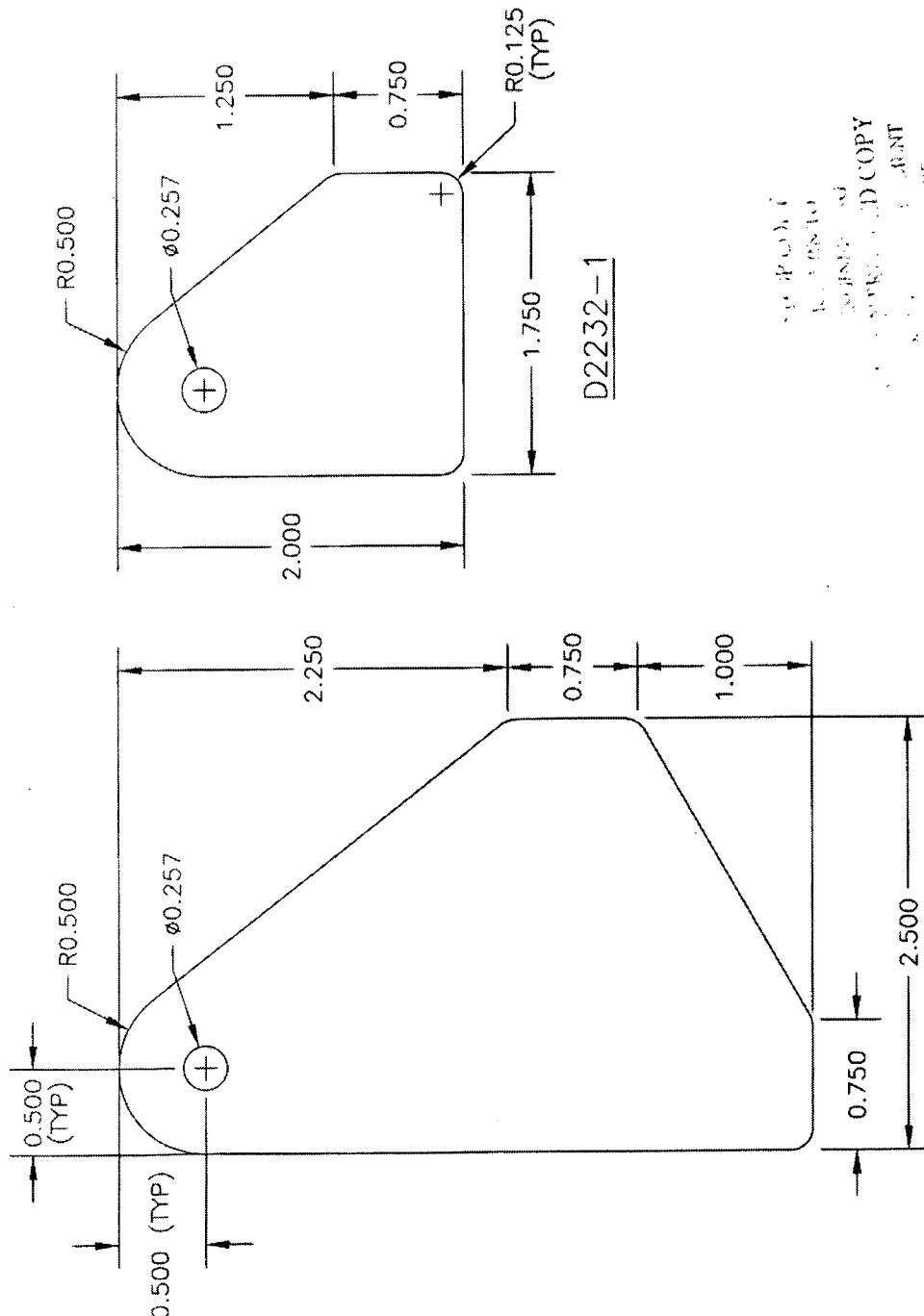
| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|---------------------------|----------|
| A | 07.05.10 | New Issue | KJ/JLM <i>[Signature]</i> | <i>B</i> |

DART

COPY
ISSUE

| | | | |
|----------|----------|---|--------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. | REV. C |
| | | D2232 | SHEET 1 OF 2 |
| DATE | | TITLE | SCALE |
| 98.04.28 | | BASKET HINGE | 1:1 |
| A | 94.05.12 | NEW ISSUE | |
| B | 96.01.02 | ADDED -5 AND -7 | |
| C | 98.04.28 | 0.125 THICK WAS 0.063 | |

RELEASED
[98.05.09 LE]



MATERIAL: AISI 304/316 SS 0.125 THICK

98362 M5
13-03-14

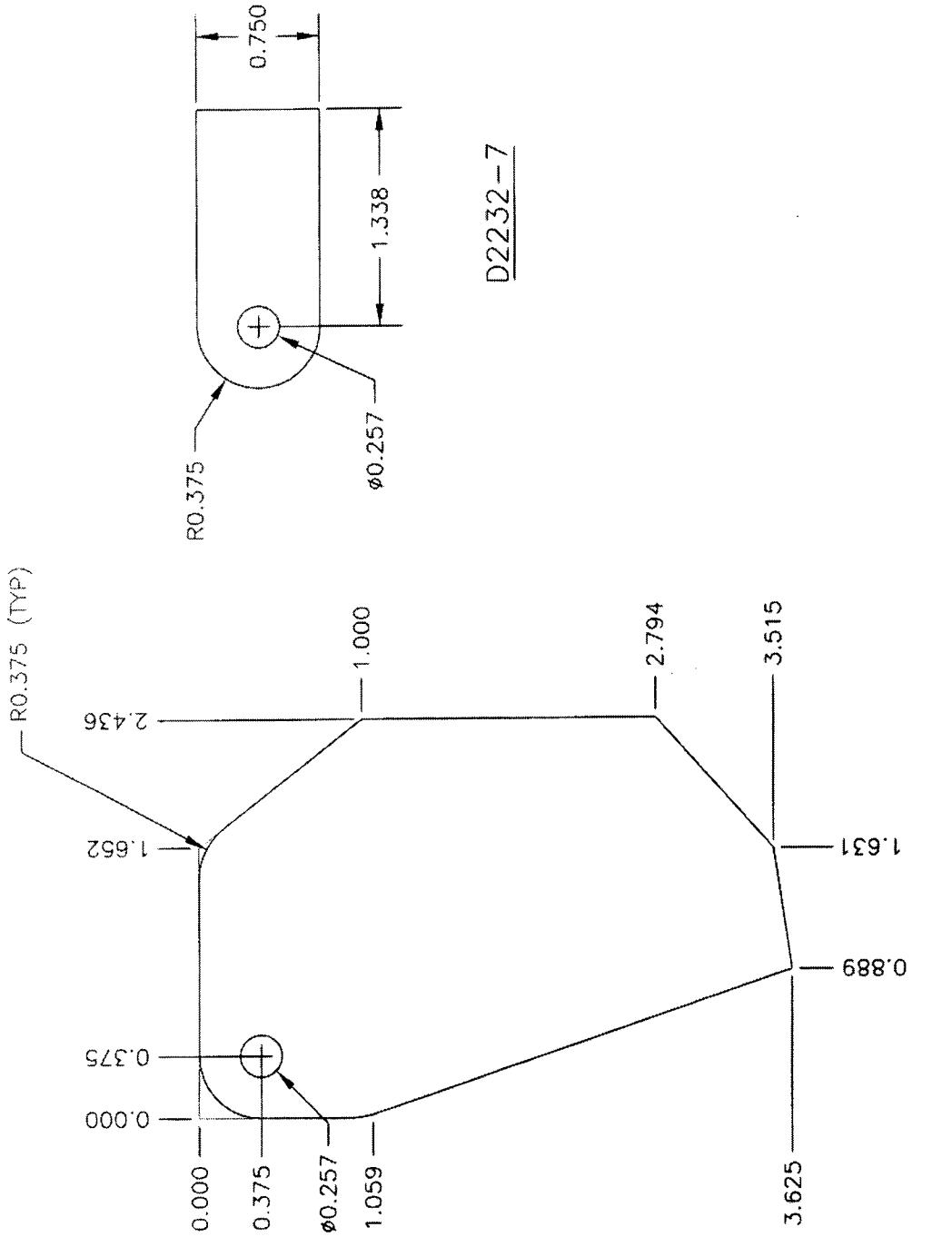
98362



| | | | | |
|--|---|---|--------|--------------|
| DESIGN  | DRAWN BY  | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | |
| CHECKED  | APPROVED  | DRAWING NO. D2232 | REV. C | SHEET 2 OF 2 |
| DATE 98.04.28 | TITLE BASKET HINGE | | SCALE | 1:1 |

RELEASED
98.05.05 KE

98.05.05 KE



MATERIAL: AISI 304/316 SS 0.125 THICK